

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008245**Date Inspected:** 10-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wei Shong Shi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Utekar Shrikant was present during the times noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress

BAY#10

FCAW welding process of weld joint 8B located on PCMK SSD1-FCSA4-1C/L. Welder is identified as 053116 ZPMC QC is identified as Zougyl. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-B-U3-F.

SAW welding process of weld joint 5A located on PCMK NSD1-7L8B/L Welder is identified as 052917 ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-C-U2B-S.

SAW welding process of weld joint 257B located on PCMK NSD1-A166C/J Welder is identified as 040460 ZPMC QC is identified as Wei Shong Shi. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-C-U2B-S

SAW welding process of weld joint 73A located on PCMK NSD1-A166E/J Welder is identified as 209051 ZPMC QC is identified as Wei Shong Shi. The welding variables recorded by QC appeared to comply with the

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WPS-B-T-2221-C-U2B-S

BAY#11

SAW welding process of weld joint 4A located on PCMK WSD1-FDSA4-4A/D. Welder is identified as 042195 ZPMC QC is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-U3C-S-2.

SAW welding process of weld joint 4B located on PCMK WSD1-FESA4-4A/F. Welder is identified as 202756 ZPMC QC is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-U3C-S-2.

SAW welding process of weld joint 64B located on PCMK WSD1-FCSA4-4A/C. Welder is identified as 040772 ZPMC QC is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-U3C-S-2.

OBG TRIAL ASSEMBLY YARD

SMAW welding process of weld joint 40 located on PCMK 1AE-EP176. Welder is identified as 047856 ZPMC QC is identified as Zhong Zheng Mao. The welding variables recorded by QC appeared to comply with the WPS-B-P-2114-FCM.

FCAW welding process of weld joint 54 located on PCMK 5BE-SP601A-001. Welder is identified as 048801 ZPMC QC is identified as Zhong Zheng Mao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

TRIAL ASSEMBLY YARD

Visual Inspection.

This QA Inspector performed a random visual inspection, prior to performing Magnetic Particle Testing of Counter weight fillet welds CW001-PP040-127, CW001-PP040-129, CW001-PP038-132 and CW001-PP038-131 and observed numerous gouges in three of the welds and an arc strike adjacent to one weld. This QA Inspector also observed several of the welds have an undercut condition at the bottom of the welds. ZPMC had identified these welds as being Magnetic Particle (MT) accepted. This condition was observed in OBG Trial assembly yard. ZPMC QA representative Mr. Shen was informed of this problem and he has stated the welds will be repaired.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials

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for your project.

Inspected By: Utekar,Shrikant

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer